

7. (Amended) A work chamfering method using a work holding portion including a first surface and a second surface, the first surface including a portion having a static friction coefficient greater than 0.1, the method comprising:

AB a first step of holding a work with the work holding portion by contacting each of the first surface and the second surface with a main surface and another main surface of the work; and

a second step of chamfering the work by using a tool;

wherein the work holding portion is adapted to rotate the work around a center of rotation;

further wherein the second surface contacts the work at at least two contacting locations; and

further wherein the center of rotation is between the contacting locations.

10. (Amended) A work chamfering method using a work holding portion including a first surface and a second surface, the first surface including a center portion and two end portions, each of the two end portions having a static friction coefficient greater than that of the center portion, the method comprising:

AM a first step of holding a work with the work holding portion by contacting each of the two end portions of the first surface with a main surface of the work and contacting the second surface with another main surface of the work; and

a second step of chamfering the work by using a tool;

wherein the work holding portion is adapted to rotate the work around a center of rotation;

further wherein the second surface contacts the work at at least two contacting locations; and

further wherein the center of rotation is between the contacting locations.

AS 12. (Amended) The method according to one of Claims 7 or 10, wherein  
the tool includes a first grinding stone and a second grinding stone, and  
the second step includes a sub-step of moving the tool thickness-wise of the work, and a sub-  
step of chamfering another edge of the work with the second grinding stone.

16. (Amended) A chamfering method for chamfering a rare-earth sintered magnet by using  
a rotating grinding stone, comprising the steps of:  
rotating the grinding stone at a speed not slower than 2000 rpm and not faster than 5000 rpm,  
and  
controlling the relative speed of the grinding stone with respect to an outer circumferential  
portion of the rare-earth sintered magnet to be not slower than 0.5 mm/sec and not faster than 7.0  
mm/sec.

AB 17. (Amended) A chamfering method for chamfering a rare-earth sintered magnet by using  
a rotating grinding stone, comprising the steps of:  
rotating the grinding stone at a circumferential speed not slower than 125.6 m/min and not  
faster than 314 m/min, and  
controlling the relative speed of the grinding stone with respect to an outer circumferential  
portion of the rare-earth sintered magnet to be not slower than 0.5 mm/sec and not faster than 7.0  
mm/sec.

Amendment under 37 C.F.R. §1.111  
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19. (Amended) The method according to Claim 16 or 17, further comprising the step of  
M supplying a coolant having a surface tension not smaller than 25 mN/m and not greater than 60  
mN/m to a grinding region.

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